



Dart Aerospace Ltd.
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D2662-1
Job Sheet 186068



Part No: D2662-1

Job Qty: 4 ea

Part Name: Saddle, LH Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP: C 00.06.22 Removed P/O for powder coat EC IPP Rev:D As per Rev D 07-03-19 JLM IPP
REV:D REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-1		
100	CNC Vertical Machining	4 pcs	11/23/18	11/23/18	0.00	5.01	HAAS1-2		
110	Mill Conv	4 pcs	11/23/18	11/23/18	0.00	2.00	Mill Conv 1 Conv. Mill 2-B4B		
120	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-1		
130	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	4 pcs	11/23/18	11/23/18	0.00	0.16	HandFinish1		
150	Powdercoat	4 pcs	11/23/18	11/23/18	0.00	0.15	Powdercoat1		
160	QC	4 pcs	11/23/18	11/23/18	0.00	0.00	QC3		
170	Packaging	4 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		
180	QC21-SA	4 Ea	11/23/18	11/23/18	0.00	0.00	QC21		

Part Op 100 - Program part number and batch number. Inspect part number and batch number are programmed MACHINE AS
Descriptions: PER FOLIO FB068 & DWG DWG REV: _____ FOLIO REV: _____

110 - Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum START TIME: 10:05 OVENTEMPERATURE: 320°
FINISH TIME: 10:35

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	64	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Specifications could not be found.

Plex 11/9/18 10:24 AM Dart.lajeunesse.marie



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order:	186068
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662	Rev: E	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621	/	3.616	3.616	3.616	3.616	
B	0.256	0.263	/	0.257	0.257	0.257	0.257	
C	0.315	0.322	/	0.316	0.316	0.316	0.316	
D	2.495	2.505	/	2.500	2.500	2.500	2.500	
E	1.674	1.684	/	1.679	1.679	1.679	1.679	
F	0.100	0.140	0	0.125	0.125	0.129	0.129	
G	0.210	0.230	/	0.226	0.225	0.229	0.229	
H	0.615	0.685	/	0.685	0.685	0.685	0.685	
I	2.470	2.510	/	2.495	2.495	2.495	2.495	
J	1.313	1.343	/	1.330	1.330	1.330	1.330	
K	0.178	0.198	/	0.188	0.188	0.188	0.188	
L	0.470	0.530	/	0.500	0.500	0.500	0.500	
M	1.125	1.145		1.144	1.144	1.144	1.144	
N	0.100	0.180		0.140	0.130	0.135	0.136	
O	0.100	0.140		0.125	0.125	0.130	0.130	
P	0.240	0.260		0.244	0.242	0.242	0.242	
Q	0.677	0.697	/	0.690	0.690	0.690	0.690	
R	0.540	0.560	/	0.544	0.544	0.544	0.544	
S	0.912	0.932		0.9125	0.922	0.9195	0.920	
T	0.787	0.807		0.804	0.800	0.7985	0.7995	
U	5.990	6.010		6.000	5.999	5.999	5.999	
V	4.995	5.005	/	5.000	5.00	5.00	5.00	
W	0.490	0.510		0.5015	0.495	0.494	0.495	
X	0.312	0.319	/	0.313	0.3125	0.3125	0.3125	
Y	0.990	1.010	/	0.999	0.999	1.000	1.0005	
Z								
AA	1.245	1.255	/	1.249	1.250	1.250	1.250	
AB	0.490	0.510		0.497	0.497	0.497	0.497	
AC	3.745	3.755	/	3.747	3.747	3.747	3.747	
AD	0.100	0.140		0.130	0.130	0.127	0.129	
AE	0.235	0.240		0.238	0.238	0.237	0.237	
AF	0.510	0.515		0.511	0.512	0.512	0.512	
AG	0.100	0.120		0.120	0.120	0.120	0.120	
AH	1.565	1.585		1.584	1.584	1.584	1.584	
Accept/Reject								

Measured by:		Date:	
Audited by:	gmm	Date:	18/11/20
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	M



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CANADA
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Container No: S128725



Part: D2662-1

Job No: 186068

Serial No/Batch: S128725

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/17/18

275, 280